



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D2573

Job Sheet 181139



Part No: D2573

Job Qty: 8 ea

Part Name: Saddle, Aft, Out



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 7/23/18

Job Tracking No:

Due Date: 7/26/18

Created By: Jesse White

Type: SOLD

Description:

Note: DWG REV F IPP: I As Per RevE 06-01-27 JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	8 Ea	7/26/18	7/26/18	0.00	0.00	Start Up Machining		SBL 18/07/23
100	CNC Vertical Machining	8 pcs	7/26/18	7/26/18	1.01	13.33	HAAS 1		SBL 18/07/23
110	Mill Conv	8 pcs	7/26/18	7/26/18	0.00	1.33	Mill Conv 1		SBL 18/07/23
130	QC	8 pcs	7/26/18	7/26/18	0.00	0.00	QC8		mark 18/07/23
140	HandFinish	8 pcs	7/26/18	7/26/18	0.00	0.38	HandFinish1		SA 18-07-30
150	Powdercoat	8 pcs	7/26/18	7/26/18	0.00	0.31	Powdercoat1		WAS-08-01
160	QC	8 pcs	7/26/18	7/26/18	0.00	0.00	QC3		9
170	Packaging	8 pcs	7/26/18	7/26/18	0.00	0.00	Packaging3	5/398 J	AUG 08 2018
180	QC21-SA	8 Ea	7/26/18	7/26/18	0.00	0.00	QC21		21 AUG 08 2018

Part Op 100 - Program Batch No. 5095199
Descriptions: 110 - Machine keyway as per dwg D2573 & D2574
150 - START TIME: _____

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D6101-007	Saddle Billet	8 Ea (1 ea)	90-Start up Operation	5069074 5095196

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D6101-007	8	36	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Saddle, Aft Outboard	0.438Inches + 0.005 - 0.000	0.443 0.438		
2	Saddle, Aft Outboard	1.745Inches + 0.010 - 0.000	1.755 1.745		
3	Saddle, Aft Outboard	3.495Inches + 0.010 - 0.000	3.505 3.495		
4	Saddle, Aft Outboard	1.745Inches + 0.010 - 0.000	1.755 1.745		

Plex 7/23/18 8:41 AM dart.white.jesse



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CANADA
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Container No: S095199



Part: D2573

Job No: 181139

Serial No/Batch: S095199

Revision:

Inspector:

Exp Date:

Instructions:

Date: 07/23/18

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S-1

5	Saddle, Aft Outboard	7.990Inches	+ 0.020 - 0.000	8.010 7.990
6	Saddle, Aft Outboard	0.490Inches	+ 0.020 - 0.000	0.510 0.490
7	Saddle, Aft Outboard	0.257Inches	+ 0.005 - 0.000	0.262 0.257
8	Saddle, Aft Outboard	0.375Inches	+ 0.005 - 0.000	0.380 0.375
9	Saddle, Aft Outboard	0.490Inches	+ 0.020 - 0.000	0.510 0.490
10	Saddle, Aft Outboard	1.174Inches	+ 0.010 - 0.000	1.184 1.174
11	Saddle, Aft Outboard	0.558Inches	+ 0.020 - 0.000	0.578 0.558
12	Saddle, Aft Outboard	1.174Inches	+ 0.010 - 0.000	1.184 1.174
13	Saddle, Aft Outboard	1.365Inches	+ 0.010 - 0.000	1.375 1.365
14	Saddle, Aft Outboard	2.495Inches	+ 0.010 - 0.000	2.505 2.495
15	Saddle, Aft Outboard	4.119Inches	+ 0.010 - 0.000	4.129 4.119
16	Saddle, Aft Outboard	0.115Inches	+ 0.020 - 0.000	0.135 0.115
17	Saddle, Aft Outboard	0.115Inches	+ 0.020 - 0.000	0.135 0.115
18	Saddle, Aft Outboard	0.240Inches	+ 0.020 - 0.000	0.260 0.240
19	Saddle, Aft Outboard	0.115Inches	+ 0.020 - 0.000	0.135 0.115
20	Saddle, Aft Outboard	0.178Inches	+ 0.020 - 0.000	0.198 0.178
21	Saddle, Aft Outboard	3.210Inches	+ 0.040 - 0.000	3.250 3.210
22	Saddle, Aft Outboard	0.230Inches	+ 0.020 - 0.000	0.250 0.230
23	Saddle, Aft Outboard	0.115Inches	+ 0.020 - 0.000	0.135 0.115
24	Saddle, Aft Outboard	0.308Inches	+ 0.005 - 0.000	0.313 0.308
25	Saddle, Aft Outboard	0.760Inches	+ 0.005 - 0.000	0.765 0.760
26	Saddle, Aft Outboard	0.352Inches	+ 0.020 - 0.000	0.372 0.352
27	Saddle, Aft Outboard	0.470Inches	+ 0.060 - 0.000	0.530 0.470
28	Saddle, Aft Outboard	0.615Inches	+ 0.020 - 0.000	0.635 0.615
29	Saddle, Aft Outboard	0.053Inches	+ 0.020 - 0.000	0.073 0.053
30	Saddle, Aft Outboard	0.240Inches	+ 0.020 - 0.000	0.260 0.240
31	Saddle, Aft Outboard	1.500Inches	+ 0.020 - 0.000	1.520 1.500
32	Saddle, Aft Outboard	0.115Inches	+ 0.020 - 0.000	0.135 0.115
33	Saddle, Aft Outboard	0.240Inches	+ 0.040 - 0.000	0.280 0.240
34	Saddle, Aft Outboard	0.240Inches	+ 0.020 - 0.000	0.260 0.240
35	Saddle, Aft Outboard	2.000Inches	+ 0.020 - 0.000	2.020 2.000
36	Saddle, Aft Outboard	0.023Inches	+ 0.020 - 0.000	0.043 0.023

DART AEROSPACE LTD	Work Order: 181139
Description: Saddle, Aft Outboard	Part Number: D2573
Inspection Dwg: D2573 Rev. F	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2573 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.438	0.443		0.438	0.438	0.438	0.438		
B	1.745	1.755		1.75	1.75	1.75	1.75		
C	3.495	3.505		3.50	3.50	3.50	3.50		
D	1.745	1.755		1.75	1.750	1.75	1.70		
E	7.990	8.010		8.004	8.004	8.003	8.003		
F	0.490	0.510		0.508	0.50	0.509	0.501		
G	0.257	0.262		0.257	0.257	0.257	0.257		
H	0.375	0.380		0.375	0.375	0.375	0.375		
I	0.490	0.510		0.5025m	0.5045	0.505	0.5045		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		0.570m	0.5705	0.573	0.573		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.365	1.375		1.370	1.370	1.370	1.37		
N	2.495	2.505		2.500	2.500	2.50	2.50		
O	4.119	4.129		4.124	4.124	4.124	4.124		
P	0.115	0.135		0.130	0.130	0.125	0.130		
Q	0.115	0.135		0.124	0.124	0.123	0.123		
R	0.240	0.260		0.252	0.252	0.252	0.252		
S	0.115	0.135		0.125	0.126	0.126	0.126		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	3.210	3.250		3.230	3.232	3.232	3.232		
V	0.230	0.250		0.241	0.241	0.237	0.238		
W	0.115	0.135		0.127	0.126	0.120	0.131		
X	0.308	0.313		0.312	0.312	0.312	0.311		
Y	0.760	0.765		0.760	0.760	0.760	0.760		
Z	0.352	0.372		0.364	0.364	0.364	0.364		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.629	0.629	0.629	0.629		
AC	0.053	0.073		0.060	0.06	0.06	0.06		
AD	0.240	0.260		0.250	0.250	0.250	0.250		
AE	1.500	1.520		1.510	1.51	1.510	1.510		
AF	0.115	0.135		0.130	0.130	0.130	0.130		
AG	0.240	0.280		0.250	0.25	0.25	0.25		
AH	0.240	0.260		0.250	0.251	0.251	0.249		
AI	2.000	2.020		2.000	2.0	2.000	2.00		
AJ	0.023	0.043		0.033	0.033	0.033	0.23		

Accept/Reject

Measured by: 57
Date: 9-89 18/07/28

Audited by: [Signature]
Date: 18/07/28

Rev	Date	Change	Revised by	Approved
B	02.09.26	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	
F	13.03.07	Dwg Rev updated	KJ	

DART AEROSPACE LTD		Work Order: 18 1139
Description: Saddle, Aft Outboard		Part Number: D2573
Inspection Dwg: D2573 Rev. F		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2573 Rev. E and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	15	26	27	48		
A	0.438	0.443		0.438	0.438	0.438	0.438		
B	1.745	1.755		1.75	1.75	1.75	1.75		
C	3.495	3.505		3.5	3.5	3.5	3.5		
D	1.745	1.755		1.75	1.75	1.75	1.75		
E	7.990	8.010		8.001	8.001	8.001	8.002		
F	0.490	0.510		.504	.502	.503	.500		
G	0.257	0.262		.257	.257	.257	.257		
H	0.375	0.380		.375	.375	.375	.375		
I	0.490	0.510		0.504	0.505	.503	.501		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		0.5735	0.571	.571	.568		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.365	1.375		1.37	1.37	1.37	1.37		
N	2.495	2.505		2.50	2.50	2.50	2.50		
O	4.119	4.129		4.124	4.124	4.124	4.124		
P	0.115	0.135		0.130	0.130	.130	.136		
Q	0.115	0.135		0.133	0.126	.124	.124		
R	0.240	0.260		0.250	0.250	0.250	0.250		
S	0.115	0.135		0.125	0.126	.126	.126		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	3.210	3.250		3.23	3.23	3.23	3.23		
V	0.230	0.250		0.238	0.238	.240	.240		
W	0.115	0.135		0.130	0.130	.130	.130		
X	0.308	0.313		.312	.311	.311	.311		
Y	0.760	0.765		.760	.760	.760	.760		
Z	0.352	0.372		.365	.366	.365	.365		
AA	0.470	0.530		0.50	0.50	0.50	0.50		
AB	0.615	0.635		.627	.627	.627	.628		
AC	0.053	0.073		0.060	0.06	0.06	0.06		
AD	0.240	0.260		0.250	0.250	0.250	0.250		
AE	1.500	1.520		1.510	1.510	1.50	1.510		
AF	0.115	0.135		0.135	0.135	.133	.133		
AG	0.240	0.280		0.250	0.250	0.250	0.250		
AH	0.240	0.260		0.253	0.253	.253	.252		
AI	2.000	2.020		2.00	2.00	2.00	2.00		
AJ	0.023	0.043		0.033	0.033	0.033	0.033		

Accept/Reject

DAS

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Date:	9-89 18/07/28

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Date:	

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